



Dart Aerospace Ltd.
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648.4702
Job Sheet 171668



001513

Part No: 648.4702

Job Qty: 1 ea

Part Name: C3 Overhaul



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/7/18

Job Tracking No:

Due Date: 2/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: O&OPM-C3 REV.4 IPP REV:A 17.12.11 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		2/15/18	0.00	0.00	Start Up Stores/Pkg-1		MLL
110	Small Fab	1 pcs		2/16/18	0.00	1.00	Small Fab-9		MLL DAS
120	QC	1 pcs		2/16/18	0.00	0.00	QC4	DAS 6	38
125	DC	1 pcs		2/16/18	0.00	0.00	DC		MAR 13 2018
130	Packaging	1 pcs		2/16/18	0.00	0.00	Packaging3-1	CEB 32	MAR 13 2018
140	QC21-FG	1 Ea		2/16/18	0.00	0.00	QC21		MAR 13 2018
Part Op 110 - Pick kit									
Descriptions: 125 - Photocopy bluefile & type labels per PPP 648.7402									
130 - Identify and pack for shipping as per PPP 648.4702									

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
188-FPSS-1032-1/4	Set Screw	2 Ea (2 ea)	90-Start up Operation	
188-FSCS-832-5/8	Clock Spring Cover Screw	4 Ea (4 ea)	90-Start up Operation	
600.1309-A	Label	1 Ea (1 ea)	90-Start up Operation	
600.1313	C3 Warning Label	1 Ea (1 ea)	90-Start up Operation	
AN4-16A	Bolt	3 Ea (3 ea)	90-Start up Operation	
C2-14-2	Label Rivets	2 Ea (2 ea)	90-Start up Operation	
C2-3-1	Bearing DU	2 (2 ea)	90-Start up Operation	
C2-3-2-1	Roller Pin Retaining Ring	2 (2 ea)	90-Start up Operation	
C2-3-3-1	Latch Roller DU Bearing	1 Ea (1 ea)	90-Start up Operation	
C2-3-5	Spacer, Teflon	2 (2 ea)	90-Start up Operation	
C2-3-8	Actuator Bushing	2 Ea (2 ea)	90-Start up Operation	
C3-10-2	Lock Spring	1 Ea (1 ea)	90-Start up Operation	
C3-12-1	Lock Bushing	2 Ea (2 ea)	90-Start up Operation	
C3-12-6 (5100-0037-SPP)	Lock Roller Retaining Ring	2 (2 ea)	90-Start up Operation	
C3-13-1 (06FDU04)	Keeper DU-Bearing Bushing	2 (2 ea)	90-Start up Operation	
C3-13-5 (DENDOFF)	Keeper Spring	1 (1 ea)	90-Start up Operation	
C3-3-4-1 (5100-0012-SPP)	Retaining Ring	4 (4 ea)	90-Start up Operation	
C3-3-9	Actuator Spring	1 (1 ea)	90-Start up Operation	
C3-4-1	Load Beam Bushing	2 Ea (2 ea)	90-Start up Operation	
C3-7-1	Load Beam Bumper	1 Ea (1 ea)	90-Start up Operation	
C3-7-2	Lock Bumper	2 Ea (2 ea)	90-Start up Operation	
C3-8-4	Solenoid Cover Gasket	1 (1 ea)	90-Start up Operation	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____ Work Order update only ☐

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS	
Part No. _____		Rework ☐	Skid-tube ☐	Water Jet ☐ Engineering ☐	
NCR No. _____		Scrap ☐	Machining ☐		
		Use-as-is ☐	Thermoforming ☐		
		Suspected Unapproved ☐	Large Fab ☐		
Date : _____	Step #: _____	QTY Effective _____			
Description Work Order Deviation					
				al	
				risor	
				ion	
				iator	
				rong	
				ensions	
				tolerance	
				ct	
				issing	
				quence	
Root Cause					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cu ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Inco ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions In ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐		
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER : _____			

Date: 03/08/18

Inspector: _____

Revision: 4

Job No: 171668

Serial No/Batch: S049167

Part: 648,4702

Container No: S049167

DART AEROSPACE

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NAS1149F0463P	Washer	8 Ea (8 ea)	90-Start up Operation
MS21044N4	Nut, Self-Locking	4 Ea (4 ea)	90-Start up Operation
AN4-17A	Bolt	1 Ea (1 ea)	90-Start up Operation
MS21083N3	Nut	2 Ea (2 ea)	90-Start up Operation
NAS1149F0332P	Washer	2 Ea (2 ea)	90-Start up Operation
MS35266-63	Solenoid Cover Screw	1 Ea (1 ea)	90-Start up Operation
NAS1149F0363P	Washer	1 Ea (1 ea)	90-Start up Operation
AN6-15A	Bolt	1 Ea (1 ea)	90-Start up Operation
MS21083N6	Nut	1 Ea (1 ea)	90-Start up Operation
NAS1149F0632P	Washer	2 Ea (2 ea)	90-Start up Operation

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	188-FPSS-1032-1/4	2	25	0
	188-FSCS-832-5/8	4	100	0
	600.1309-A	1	0	0
	600.1313	1	6	0
	→ AN4-16A	3	245	0
	→ AN4-17A	1	699	0
	→ AN6-15A	1	7	0
	C2-14-2	2	0	0
	→ C2-3-1	2	0	0
	C2-3-2-1	2	0	0
	→ C2-3-3-1 050406	1	0	0
	C2-3-5	2	0	0
	C2-3-8	2	0	0
	C3-10-2	1	0	0
	C3-12-1	2	40	0
	C3-12-6 (5100-0037-SPP)	2	0	0
	C3-13-1 (06FDU04)	2	0	0
	C3-13-5 (DENDOFF)	1	0	0
	→ C3-3-4-1 (5100-0012-SPP)	4	0	0
	C3-3-9	1	0	0
	→ C3-4-1	2	0	0
	C3-7-1	1	0	0
	C3-7-2	2	0	0
	C3-8-4	1	0	0
	→ MS21044N4	4	39	0
	→ MS21083N3	2	100	0
	→ MS21083N6	1	30	0
	→ MS35266-63	1	50	0
	→ NAS1149F0332P	2	3,883	0
	→ NAS1149F0363P	1	285	0
	→ NAS1149F0463P	8	174	0
	→ NAS1149F0632P	2	60	0

Part Specifications

Specifications could not be found.

WORK ORDER NON-CONFORMANCE / UPDATE

QA: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐ Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐		AGAINST DEPARTMENT/PROCESS			
Site: _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation				Disposition			
				Completed By			
				Lead hand / Supervisor Approval Verification			
				QC / QA Coordinator Approval			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ External Transport ☐ Technical Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		FAULT CATEGORY Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____							